

Sun 1

Dart Aerospace Ltd.

Date: Thursday, 23/04/2009 1:40:11 PM
 User: Julie Dawson

Process Sheet

| | | | | | | | |
|-----------------------|---|--|--|------------------|-------------------------------|--|--|
| Customer | : CU-DAR001 Dart Helicopters Services | | | Drawing Name | : SADDLE ASSEMBLY | | |
| Job Number | : 47406B | | | Part Number | : D2282043 | | |
| Estimate Number | : 11180 | | | Drawing Number | : D2282 REV E | | |
| P.O. Number | : | | | Project Number | : N/A | | |
| This Issue | : 23/04/2009 S.O. No. : | | | Drawing Revision | : E | | |
| Prsht Rev. | : NC | | | Material | : | | |
| First Issue | : / / Type : SMALL /MED FAB | | | Due Date | : 30/04/2009 Qty: 60 Um: Each | | |
| Previous Run | : 46685 | | | | | | |
| Written By | : | | | | | | |
| Checked & Approved By | : 2009.04.23 | | | | | | |
| Comment | : Est Rev:A Removed from 9 Digit 05-12-02 JLM | | | | | | |

Additional Product

Job Number:



| Seq. #: | Machine Or Operation: | Description : | | |
|---|-----------------------|---|--|--|
| 1.0 | D2281 | Jack Saddle | | |
| | |  | | |
| Comment: Qty.: 1.0000 Each(s)/Unit Total : 60.0000 Each(s) Pick: Qty Part Number Description Batch 1 D2281 Saddle <u>B4S38-3=25X</u> <u>B46831=35X</u> | | | | |
| | |  | | |
| 2.0 | D22827 | Tube | | |
| | |  | | |
| Comment: Qty.: 2.0000 Each(s)/Unit Total : 120.0000 Each(s) Pick: Qty Part Number Description Batch <u>B46890=119</u> 2 D22827 tube <u>B45384=1</u> | | | | |
| 3.0 | LARGE FAB 1 | LARGE FABRICATION RESOURCE 1 | | |
| | |  | | |
| Comment: LARGE FABRICATION RESOURCE 1 1-Weld as per D2282-043 Saddle Assembly | | | | |
| 4.0 | SMALL FAB 1 | SMALL & MEDIUM FAB RESOURCE 1 | | |
| | |  | | |
| Comment: SMALL & MEDIUM FAB RESOURCE 1 1- grind weld flush, take all welding marks out and deburr holes | | | | |

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No, DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
| | | | | | | | | |
| | | | | | | | | |
| | | | | | | | | |

NOTE: Date & initial all entries

Date: Thursday, 23/04/2009 1:40:11 PM
User: Julie Dawson

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SADDLE ASSEMBLY

Job Number: 47406B

Part Number: D2282043

Job Number:



Seq. #: Machine Or Operation:

Description :

5.0 QC9

VISUAL WELDING INSPECTION



PJL 09-05-27

Comment: VISUAL WELDING INSPECTION

6.0 QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

SB 09/05/27

60

7.0 SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

1-tumble

N/A

8.0 QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

9.0 PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: *GI*

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60

10.0 QC21

FINAL INSPECTION/W/O RELEASE



09/05/27

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



*MF
09-05-27*

| W/O: | | WORK ORDER CHANGES | | | | | |
|----------|--------|--|----|----------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| 09.05.27 | 7 8 | Steps no longer necessary. To reduce lead time, parts will be polished with a blue pad, and no longer tumbled. Perm change. | PC | 09.05.27 | 1 | 09.05.27 | 09.05.27 |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

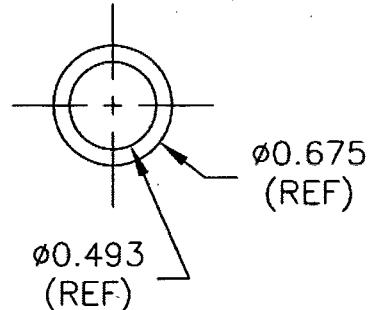
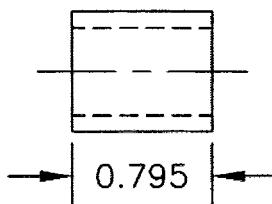
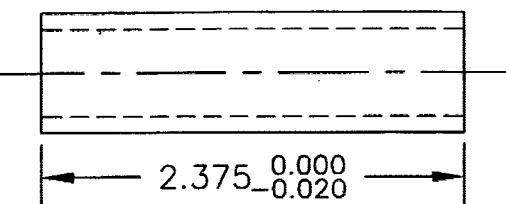
| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
| | | | | | | | | |
| | | | | | | | | |
| | | | | | | | | |

NOTE: Date & initial all entries

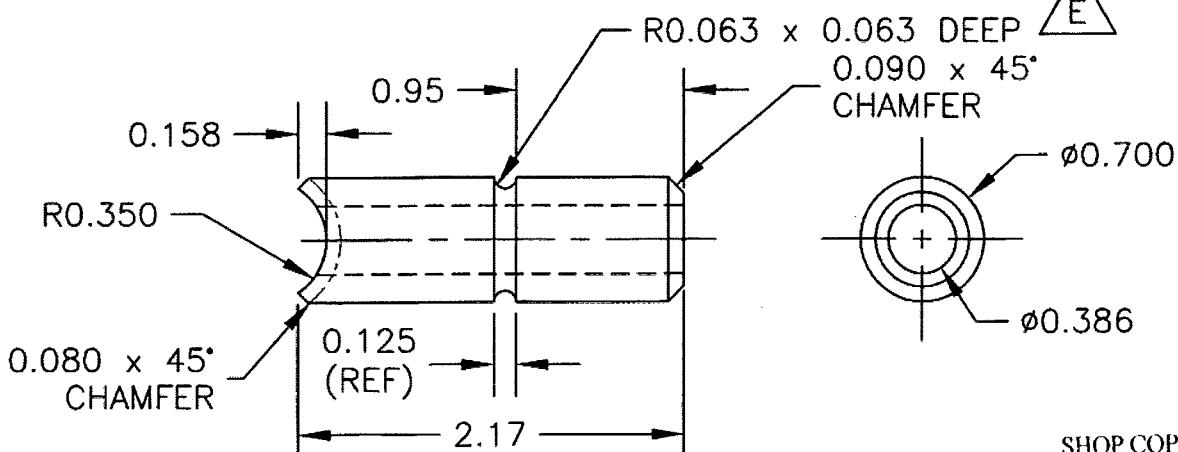
DART

| | | | |
|----------------------|-----------------------|---|------------------------|
| DESIGN BW | DRAWN BY <i>IP</i> | DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA | |
| CHECKED <i>IP</i> | APPROVED <i>IP</i> | DRAWING NO. D2282 | REV. E SHEET 1 OF 2 |
| DATE 05.06.07 | TITLE HANDLE TUBES | SCALE 1:1 | |

RELEASED
BS/09/16

D2282-3D2282-7D2282-3/-7 TUBE:

- 1) MATERIAL: T304/T316 3/8 SCHEDULE 40 (REF. DART SPEC. M304TR0.675W.091)
- 2) BREAK ALL UNMARKED SHARP EDGES 0.005 TO 0.010
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

D2282-5D2282-5 STEM:

- 1) MATERIAL: AISI 304 STAINLESS STEEL (REF. DART SPEC. M304R0.750)
- 2) BREAK ALL UNMARKED SHARP EDGES 0.005 TO 0.010
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

SHOP COPY

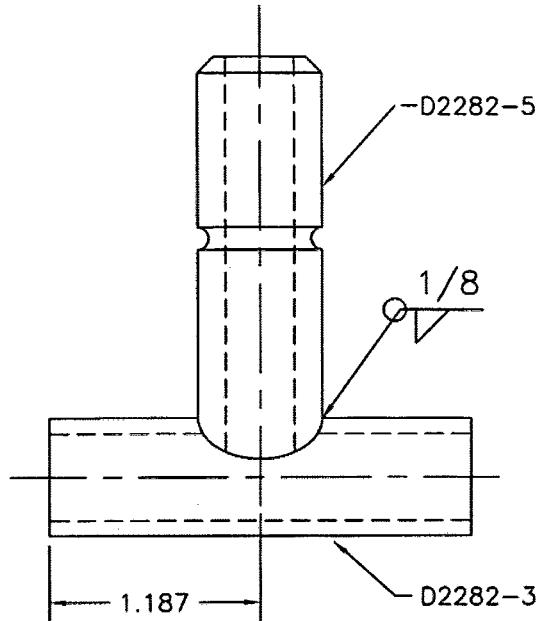
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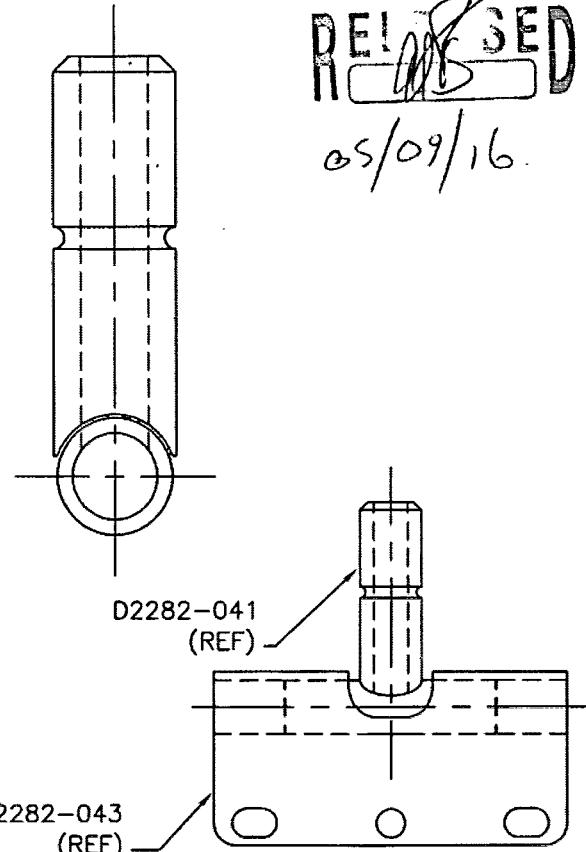
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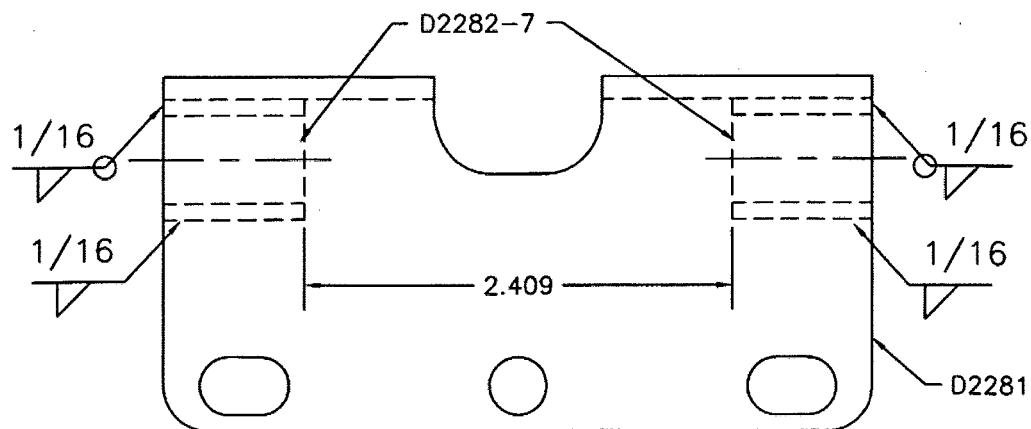
| | | |
|----------------------|-----------------------|---|
| DESIGN BW | DRAWN BY <i>RF</i> | DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA |
| CHECKED <i>UP</i> | APPROVED <i>AB</i> | DRAWING NO. D2282 REV. E SHEET 2 OF 2 |
| DATE 05.06.07 | | TITLE HANDLE TUBES SCALE 1:1 |



D2282-041 'T' ASSEMBLY
WELD ASSEMBLY PER DART QSI 004



GENERAL ASSEMBLY
SCALE 1:2



D2282-043 SADDLE ASSEMBLY
WELD ASSEMBLY PER DART QSI 004

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